



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3200-1
Job Sheet 170427



Part No: D3200-1

Job Qty: 20 ea

Part Name: Door Post Block



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 1/31/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A Removed from 9 Digit 06-01-25 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	1/30/18	1/30/18	0.00	0.00	Start Up Machining-2		mark B/01/27
100	Bandsaw	20 pcs	1/30/18	1/30/18	0.00	0.18	Bandsaw1		"
110	CNC Vertical Machining	20 pcs	1/31/18	1/31/18	0.07	6.58	HAAS1-3		"
130	QC	20 pcs	1/31/18	1/31/18	0.00	0.00	QC8 Machining-2		18/01/30
140	Packaging	20 pcs	1/31/18	1/31/18	0.00	0.00	Packaging3-1	ST 022	JAN 31 2018
150	QC21-SA	20 Ea	1/31/18	1/31/18	0.00	0.00	QC21		

Part Op 100 - Cut blank: 2.700" x 2.700

Descriptions: 110 - 1-Machine D3200-1 as per Folio FA337 and Dwg D3200

JAN 31 2016

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MUHMWB10	1	713	0	0

Batch # FM136453

304 = 652 p2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid- Mach Thermoform Large		ering ☐ ality ☐ other ☐ 2) Approval ☐ ted By ☐ Supervisor ☐ rification ☐ rdinator ☐ val ☐ Wrong ☐ tensions ☐ tolerance ☐ ct ☐ issing ☐			
Date : _____		Step #: _____		QTY _____					
Description Work Order Deviation									
Root Cause <table style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%;"> <tr> <td style="width:50%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> Temperature/C ☐ Set-up ☐ BOM/Route ☐ Broken/Damage ☐ Inspection Incoi ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incc ☐ Drill Holes ☐ </td> </tr> </table>		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/C ☐ Set-up ☐ BOM/Route ☐ Broken/Damage ☐ Inspection Incoi ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incc ☐ Drill Holes ☐	Misaligned/off center ☐ Turning Sequence ☐	
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OTHER : _____									

PART NO: D3200-1
Original Serial #: S036514
Revision:
Operation:
Change No:

Job No: 170427
 Start up Operation 01/29/18



S036514



Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Post Block	0.196inches + 0.005 - 0.000	0.201 0.196		
2	Door Post Block	0.405inches ± 0.010	0.415 0.395		
3	Door Post Block	100Degrees ± 0	100 100		
4	Door Post Block	0.100inches ± 0.010	0.110 0.090		
5	Door Post Block	0.130inches ± 0.010	0.140 0.120		
6	Door Post Block	1.630inches ± 0.005	1.635 1.625		
7	Door Post Block	0.440inches ± 0.030	0.470 0.410		
8	Door Post Block	2.500inches ± 0.010	2.510 2.490		
9	Door Post Block	1.845inches ± 0.010	1.855 1.835		
10	Door Post Block	1.000inches ± 0.010	1.010 0.990		
11	Door Post Block	1.620inches ± 0.050	1.670 1.570		
12	Door Post Block	2.500inches ± 0.030	2.530 2.470		
13	Door Post Block	0.750inches ± 0.030	0.780 0.720		

Plex 1/16/18 11:25 AM dart.lacelle.linda

DQA: _____ Date: _____



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Work Order update only ☐

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
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OTHER : _____																					